

Date: Friday, 03/11/2006 7:48:20 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR PANEL
Job Number	: 29243	Part Number	: D32961
Estimate Number	: 11401	Drawing Number	: D3296 REV A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 03/11/2006	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Revision	: A
First Issue	: / /	Material	: P/A
Previous Run	: 29243	Due Date	: 24/11/2006
Written By	:		
Checked & Approved By	:		
Comment	: Est 05.10.14 Added step 14 KJ/EC Est Rev:D Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.6926 sf(s)/Unit Total : 5.5406 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-1 Batch: M10222	ml 08 11 09 (8)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3296 Dwg Rev: A Prog Rev: A	ml 08 11 09 (8)
	2-Deburr if necessary		SAD 08.11.12 (8)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	ml 08 11 09 (8)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	ml 08 11 09 (8)

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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
8.0	D31617	Hinge 14"
9.0	D31619	Hinge 17"
10.0	MS20470AD44	Rivet, Universal Head

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Job Number: 		
Seq. #:	Machine Or Operation:	Description :
11.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble hinges as per Dwg D32961
12.0	QC5 	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP
13.0	POWDER COATING 	POWDER COATING  Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3
14.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
15.0	PACKAGING 1 	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA <i>mloef/11/17</i>
16.0	QC21 	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE <i>11/11/20</i>
Job Completion 		<i>U 26/11/20</i>

DART AEROSPACE LTD	Work Order:	29243
Description: Door Panel	Part Number:	D3296-1
Inspection Dwg: D3296	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>M</u>	Prototype Approval:	N/A
Date:	01/09	Date:	06/11/09	Date:	N/A

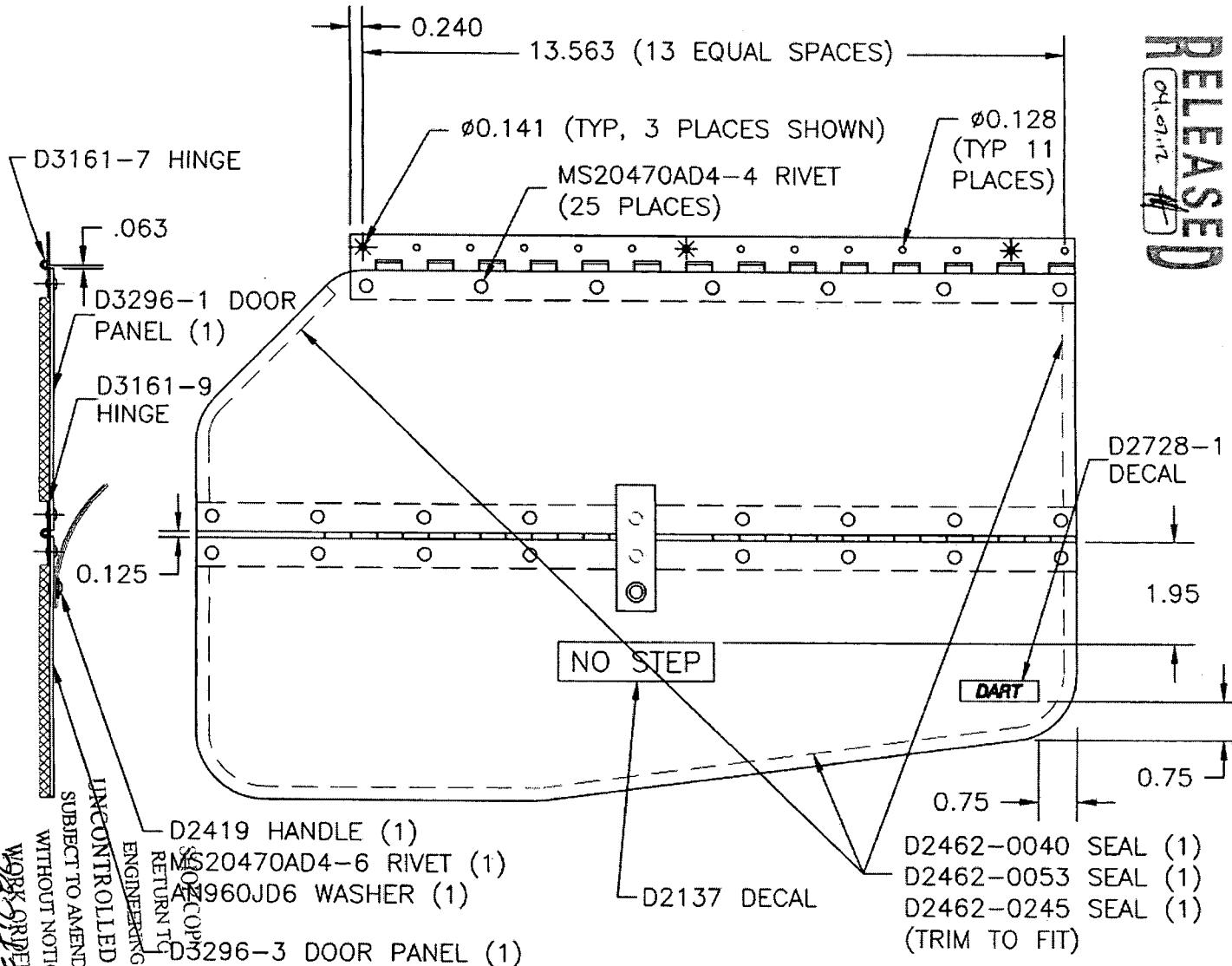
Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	P/O D3296-041	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

RELEASED
04.07.12

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
IP	IP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. A 1 OF 2
DATE	TITLE	D3296
04.06.28	DOOR ASSEMBLY	
A	04.06.28	NEW ISSUE



D3296-1 DOOR ASSEMBLY

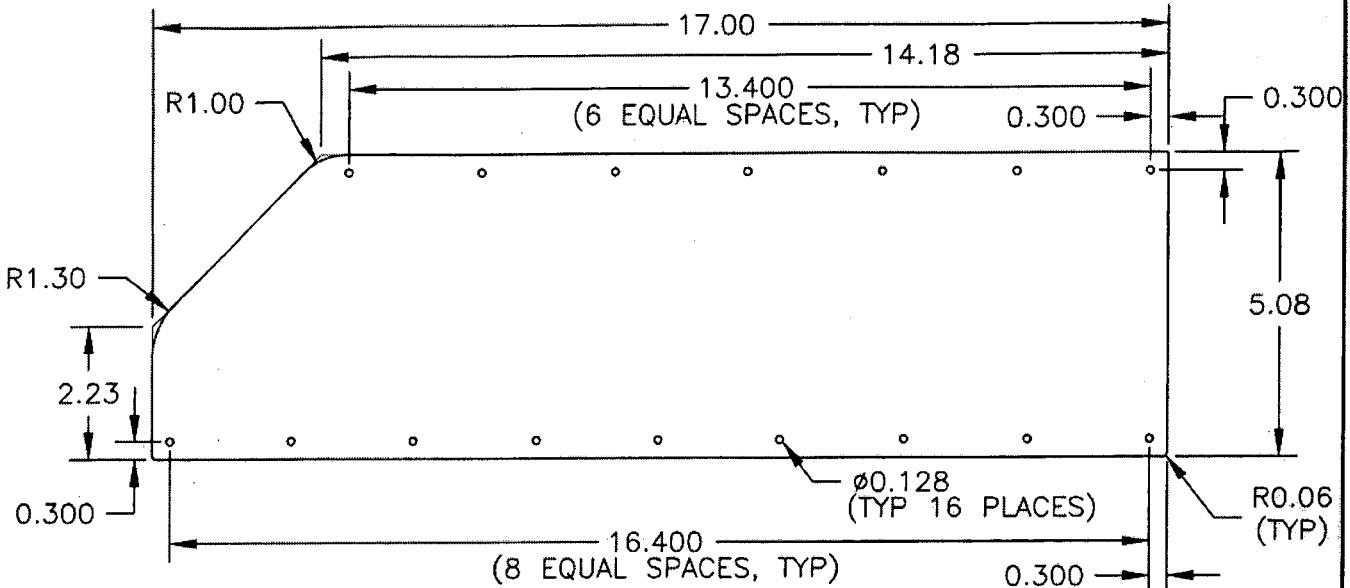
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



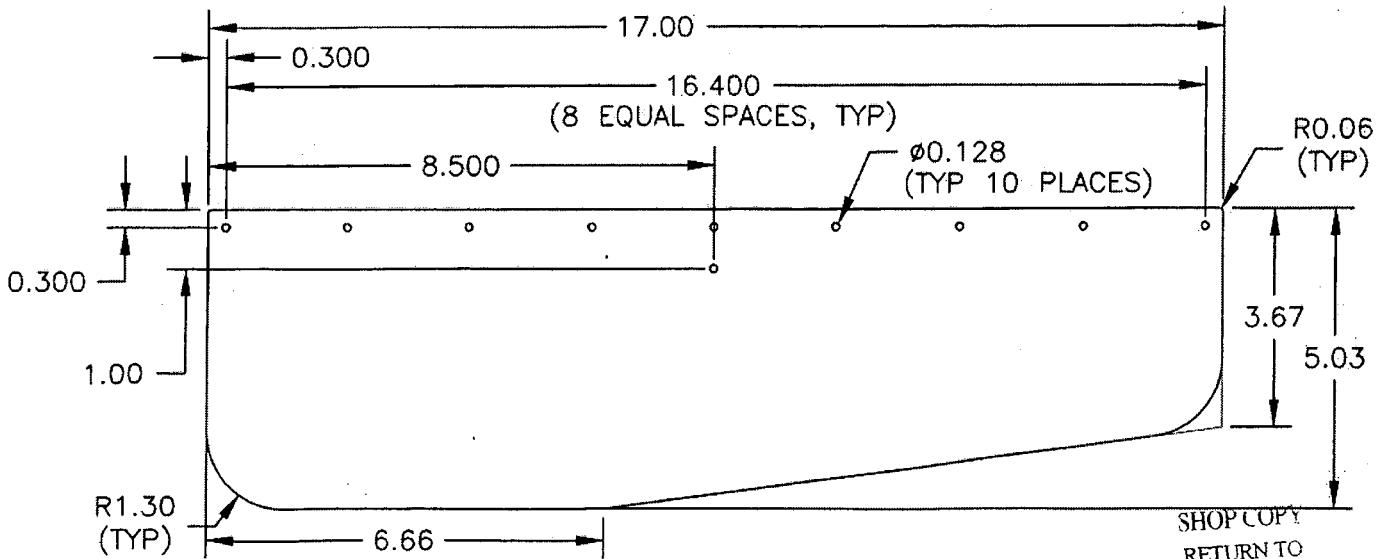
DESIGN	DRAWN BY
<i>CP</i>	<i>CP</i>
CHECKED	APPROVED
<i>MM</i>	<i>MM</i>
DATE	
04.06.28	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A
2 OF 2
SCALE
1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

~~SHOP COPY
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ENGINEERING
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EFFECTIVE AMENDMENT
WITHOUT NOTICE~~

WORK ORDER
NO. 29243

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